



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBH9928-2-3
Job Sheet 168622



Part No: RBH9928-2-3

Job Qty: 3 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/20/17

Job Tracking No:

Due Date: 11/24/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBH9928-2 Rev10 U/R IPP Rev A 17.11.15 New issue DP Verify DD/IPP Rev B 17.11.20 DWG Rev K
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		11/23/17	0.00	0.00	Start Up Machining-3		2018/01/12
100	Mori Seiki	3 pcs		11/24/17	0.00	3.00	MORI NV5000-2		2018/01/12
110	QC	3 pcs		11/24/17	0.00	0.00	QC2 Machining-3		2018/01/12
120	QC	3 pcs		11/24/17	0.00	0.00	QC8 Machining-4		2018-01-18
140	QC	3 pcs		11/24/17	0.00	0.00	QC5		30
150	Outsource	3 pcs		11/24/17	0.00	0.00	Outsource4		AT 18/01/11
160	Packaging	3 pcs		11/24/17	0.00	0.00	Packaging2		AT 18/01/11
170	QC	3 pcs		11/24/17	0.00	0.00	QC6		30
175	Packaging	3 pcs		11/24/17	0.00	0.00	Packaging3		30
180	QC21-SA	3 Ea		11/24/17	0.00	0.00	QC21		30

Part Op 100 - 1-Machine as per folio FB FOLIO REV: DWG REV: K 2-Deburr NOTE;
Descriptions: ***Machine RBH9928-2-1 at same time***

~~120 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG~~

150 - Issue P/O to ATG : PO 038501 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

JAN 31 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.250X06.000	0	32	0	0

Part Specifications

Specifications could not be found.

S025654 → S032311

Plex 11/20/17 10:18 AM Dart.lajeunesse.marie

1 clamp

2.5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

Date : _____



Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Clamp

PART NO: RBH9928-2-3
Original Serial #: S032344
Revision:
Operation: Start up Operation
Change No:

01/15/18
Job No: 168622

FAST DEPARTMENT/PROCESS

ibe ☐	Water Jet ☐	Engineering ☐
fab ☐	Prod. Eng. Coord. ☐	Quality ☐
ing ☐	Rec/Store/Packaging ☐	Other ☐
ite ☐	Supplier ☐	

MRB (QSI042) Approval

tion

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment ☐	No Re-verification ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Setup ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Information ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

☐ Pressure/Forced
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Wave/Twist in Tube
☐ Marks/Chatter

FAULT CATEGORY

☐ Temperature/Cure
☐ Set-up
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

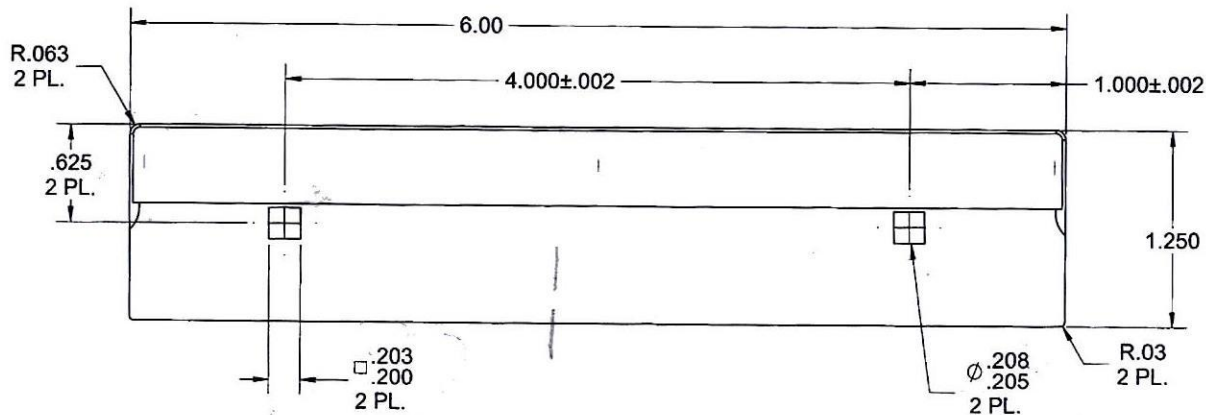
☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Mislabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

OTHER :

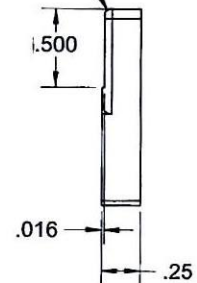
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168622 M.S
17-11-20

6.060



RBH9928-2-3 CLAMP

R.063
ALONG THE EDGE



NOTES:

- 1) MATERIAL: 6061-T6
- 2) FINISH: RED ANODIZE
- 3) HEAT TREAT: N/A
- 4) SPEC: MIL-A-8625, TYPE II, CLASS 2; WATER SEALANT
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE CLAMP			
DWG NO. RBH9928-2-3		REV K	
DESIGN BY:	VM 9/22/2017	JOCK ± .005	FRACTIONS 2/16
DRAWN BY:	WM 11/15/2017	XX ± .01	ANGLES ± 5°
CHECKED:	WM 11/15/2017	X	SURFACES = 125
MFG. APPR:	DP 11/16/2017	1. DIMENSIONS ARE IN INCHES	
APPROVED:	WM 11/16/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	11/15/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.2 LBS
		SHEET 3 OF 3	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



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PURCHASE ORDER PO038921

				Items						
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Roof Doubler Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 647.0100 Rev. A							
9	168598	RBH9928-2-1	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	4 pcs	0 pcs	4 pcs	\$7.30/pcs	\$29.20
10	168599	RBH9928-2-3	Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	4 pcs	0 pcs	4 pcs	\$7.30/pcs	\$29.20
						✓ 4x		AT 18/02/11		
11	168620	RBH9928-2-1	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	3 pcs	0 pcs	3 pcs	\$7.30/pcs	\$21.90
12	168622	RBH9928-2-3	Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	3 pcs	0 pcs	3 pcs	\$7.30/pcs	\$21.90
						✓ 3x		AT 18/02/11		
13	168651	RBH9928-2-1	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	3 pcs	0 pcs	3 pcs	\$7.30/pcs	\$21.90
						✓ 3x		AT 18/02/11		
14	168654	RBH9928-2-3	Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/9/18	3 pcs	0 pcs	3 pcs	\$7.30/pcs	\$21.90
15	168944	RBH9928-12-3	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2,	Firmed	2/9/18	1 pcs	0 pcs	1 pcs	\$7.30/pcs	\$7.30
						✓ 1x		AT 18/02/11		

DAS
38
9-08



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914608

Date: 09-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 015 652-5577 Fax: 015 652-5577		Ship Via	
Terms		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: RBH9928-2-3 Rev: K Clamp Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22470 PO: PO038921 Line: 10		
3 ea	Part: RBH9928-2-3 Rev: K Clamp Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22472 PO: PO038921 Line: 12		
3 ea	Part: RBH9928-2-1 Rev: K Tab Bender Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22473 PO: PO038921 Line: 13 or 11		
1 ea	Part: RBH9928-12-3 Rev: C Tab Bender Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (4 - 1 mils). Water Sealant Job: 22475 PO: PO038921 Line: 15		
4 ea	Part: D5227-3 Rev: A Seat Track Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22465 PO: PO038921 Line: 5		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914608

Date: 09-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Date: <u>02/02/2018</u>	
	Certified Signature: <u>[Signature]</u>	
	Receiver Signature: _____	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada.	